

P802207/WO/1

- 11 -

DaimlerChrysler AG

New patent claims

- 5 1. A method for joining at least one joint part (3),
provided with a through-opening (4), to a hollow profile (1),
- in which the joint part (3) is pushed with its through-
opening (4) onto the hollow profile (1) up to a joint
point (2),
10 - in which the hollow profile (1) is expanded at least at
the joint point (2),
- in which an adhesive (11) is arranged between an inner
side (6) of the joint part (3) and an outer side (5) of
the hollow profile (1) before the expansion in such a
15 way that the adhesive (11) adheres to the inner side (6)
of the joint part (3) and to the outer side (5) of the
hollow profile (1) in the region of the joint point (2)
after the expansion,
characterized in that the adhesive (11) is arranged in a
20 recess (12) which fully extends in an annular manner in
the circumferential direction, is formed on the inner
side (6) of the joint part (3) or on the outer side (5)
of the hollow profile (1) before the expansion and is
essentially leveled after the expansion.
25
2. The method as claimed in claim 1, characterized in
that the adhesive (11) is arranged in such a way that it
fully encloses the hollow profile (1) in an annular
manner in the circumferential direction.
30
3. The method as claimed in claim 1 or 2, characterized
in that the adhesive (11) is arranged in the form of a
solid on the inner side (6) or on the outer side (5)
before the joint part (3) is pushed onto the hollow

AMENDED SHEET

profile (1).

4. The method as claimed in one of claims 1 to 3, characterized

- 5 - in that the hollow profile (1) is also expanded directly adjacent to the joint part (3) in such a way that
- the hollow profile (1) has, after the expansion, at least on one side of the joint part (3), a step (13)
- 10 bearing laterally against the joint part (3).

5. The method as claimed in one of claims 1 to 4, characterized in that the hollow profile (1) is expanded by means of internal high pressure at least at the joint

15 point (2).

6. A hollow profile having a joint part (3) joined thereto,

- the joint part (3) being pushed with its through-
- 20 opening (4) onto the hollow profile (1) up to a joint point (2),
- the hollow profile (1) being expanded at least at the joint point (2),
- an adhesive (11) being arranged between an inner side
- 25 (6) of the joint part (3) and an outer side (5) of the hollow profile (1), this adhesive (11) adhering to the inner side (6) and to the outer side (5),
- the hollow profile (1) being expanded directly adjacent to the joint part (3) in such a way that it bears
- 30 laterally against the joint part (3) by means of a step (13),

characterized in that

the hollow profile (1), for forming the step (13), is expanded only in an annular-bead-like section adjoining

the joint part (3).

7. The hollow profile as claimed in claim 6,
characterized in that the joint part (3) has a fastening
5 section (7) with which a combination (8) of joint part
(3) and hollow profile (1) can be fastened to another
component.